

Work Order ID 75252

October-19-11 1:35:54 PM

75252

Page 1

Item ID: D2857-2 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Hinge Bracket
 Start Date: 19/10/2011 Start Qty: 24.00 ***24*** Cust Item ID:
 Required Date: 07/11/2011 Req'd Qty: 24.00 ***24*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 11/10/11 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2857	Rev C								

100 0.00
100 BAND SAW
 Bandsaw Memo 0.00 out 11/10/11 24 ✓
 Jeaspa Bandsaw Cut blanks 4.425"

110 0.00
110 HAAS CNC VERTICAL MACHINING #1
 HAAS I Memo 0.00 F.K. 11/11/03 24 ✓
 HAAS CNC vertical machine #1
 1-Machine per folio FA940
 FOLIO REV: E
 DWG REV: C
 2-Deburr any rough edges

120 0.00
120 QC2- Inspect parts off machine FAI/FAIB
 QC Memo 0.00 F.K. 11/11/03 24 ✓
 Quality Control

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.00							
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									
150	QC3- Inspect Part Finish	0.00							
150									
QC	Memo	0.00							
Quality Control									

ml 11/11/03

24

24 BR 11-11-4

24 X 11/11/04

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Page 3

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 19/10/2011 **Start Qty:** 24.00

24

Cust Item ID:**Required Date:** 07/11/2011 **Req'd Qty:** 24.00

24

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

160

Memo

0.00

Powdercoat

START TIME:

OVEN TEMPERATURE:

Powder Coating

FINISH TIME:

400

QC3- Inspect Part Finish

0.00

170

Memo

0.00

OC

Quality Control

Identify as per dwg & Stock Location: 024

0.00

180

Memo

0.00

Packaging

Packaging

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Work Order ID 75252***75252***

Page 4

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

11/11/11
MK
11-11-08

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Picklist Print

October-19-11 1:35:58 PM

Page 1

Work Order ID: 75252

75252

Parent Item: D2857-2

D2857-2

Parent Item Name: Hinge Bracket

Start Date: 19/10/2011

Required Date: 07/11/2011

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP C 00.06.22 Removed P/O for powder coatEC
IPP D 06.03.30Added level 8 EC IPP Rev:E 11.01.06 as
per dwg revC DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.000X01.25 0		Purchased		No		100	f	66.3026	0.37	9.347368			

M6061T6B2 000X01 250

6061-T6 Bar 2.00 x 1.25

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT010	66.30263158	
114899	4.15263158	
116623	2.15	
→ 119136	60	

9.35 *and 11/10/31*

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DART AEROSPACE LTD		Work Order:	75252
Description: Hinge Bracket		Part Number:	D2857-2
Inspection Dwg: D2857 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.300	+/-0.010	4.299	✓		FK-04	Vern
4.000	+/-0.010	4.000	✓		31006	Height gage
0.340	+/-0.010	.339	✓		FK-04	Vern
1.110	+/-0.005	1.110	✓		"	"
1.790	+/-0.010	1.79	✓		"	"
1.320	+/-0.005	1.320	✓		"	"
2.000	+/-0.010	2.000	✓		"	"
0.340	+/-0.010	.339	✓		"	"
0.447	+/-0.010	.447	✓		"	"
Ø0.171	+0.005/-0.000	.172	✓		"	"
0.147	+/-0.010	.147	✓		"	"
0.376	+/-0.010	.377	✓		"	"
0.126	+/-0.010	.127	✓		"	"
0.063	+/-0.010	.064	✓		"	"
						"
Ø0.166	+0.005/-0.000	.166	✓		"	"
0.911	+/-0.010	.916	✓		"	"
0.600	+/-0.010	.600	✓		"	"
						"
0.125	+/-0.010	.125	✓		"	"
0.150	+/-0.010	.150	✓		"	"

Measured by: F.K.	Audited by: amf	Prototype Approval:	N/A
Date: 11/11/03	Date: 11/11/03	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.15	New Issue	KJ/JLM	
B	07.04.20	Dimensions update per Dwg Rev B	KJ/JLM	

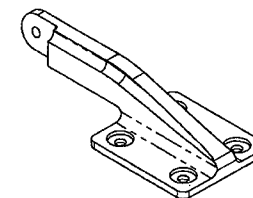
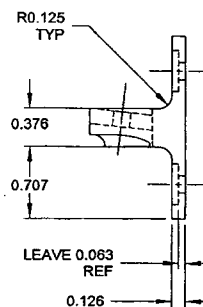
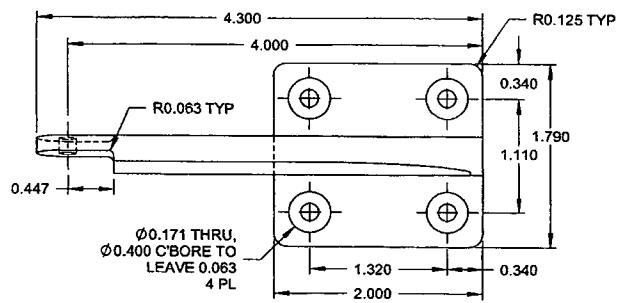
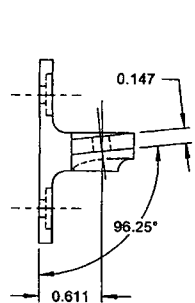
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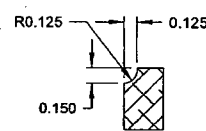
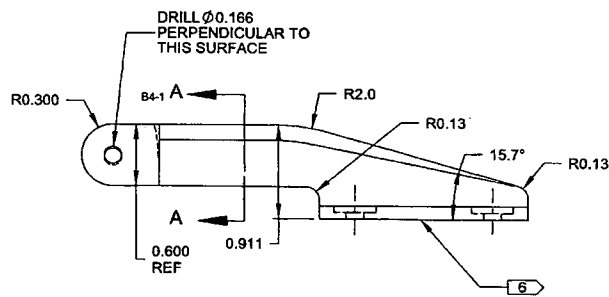
NOTE: Date & initial all entries



SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 75252 M.L.J

11/10/19

RELEASED
R 2010-11-26



SECTION A-A

D2857-1 HINGE BRACKET

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM BAR PER QQ-A-200/8 OR QQ-A-225/8 OR ASTM B211 OR ASTM B221 REF DART SPEC M6081T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: P/N "D2857-1" PER DART QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: 0.11 lbs

C	REFORMAT DWG. IDENTIFICATION BY MARKER WAS ENGRAVING (A8-1), REF PAR 10-040	CP	10.09.13
B	ADD THICKNESS, REDRAW W/ SOLIDWORKS	LE	08.08.28
A	NEW ISSUE	KE	98.12.14
REV.	DESCRIPTION	BY	DATE
DESIGN	KE		
DRAWN	DP		
CHECKED	DP		
MFG. APPR.	DP		
APPROVED	DP		
DE APPR.	DP		
DATE	10.09.13		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2857 TITLE HINGE BRACKET REV. C SHEET 1 OF 2 SCALE NTS COPYRIGHT © 1998 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. WHEN SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

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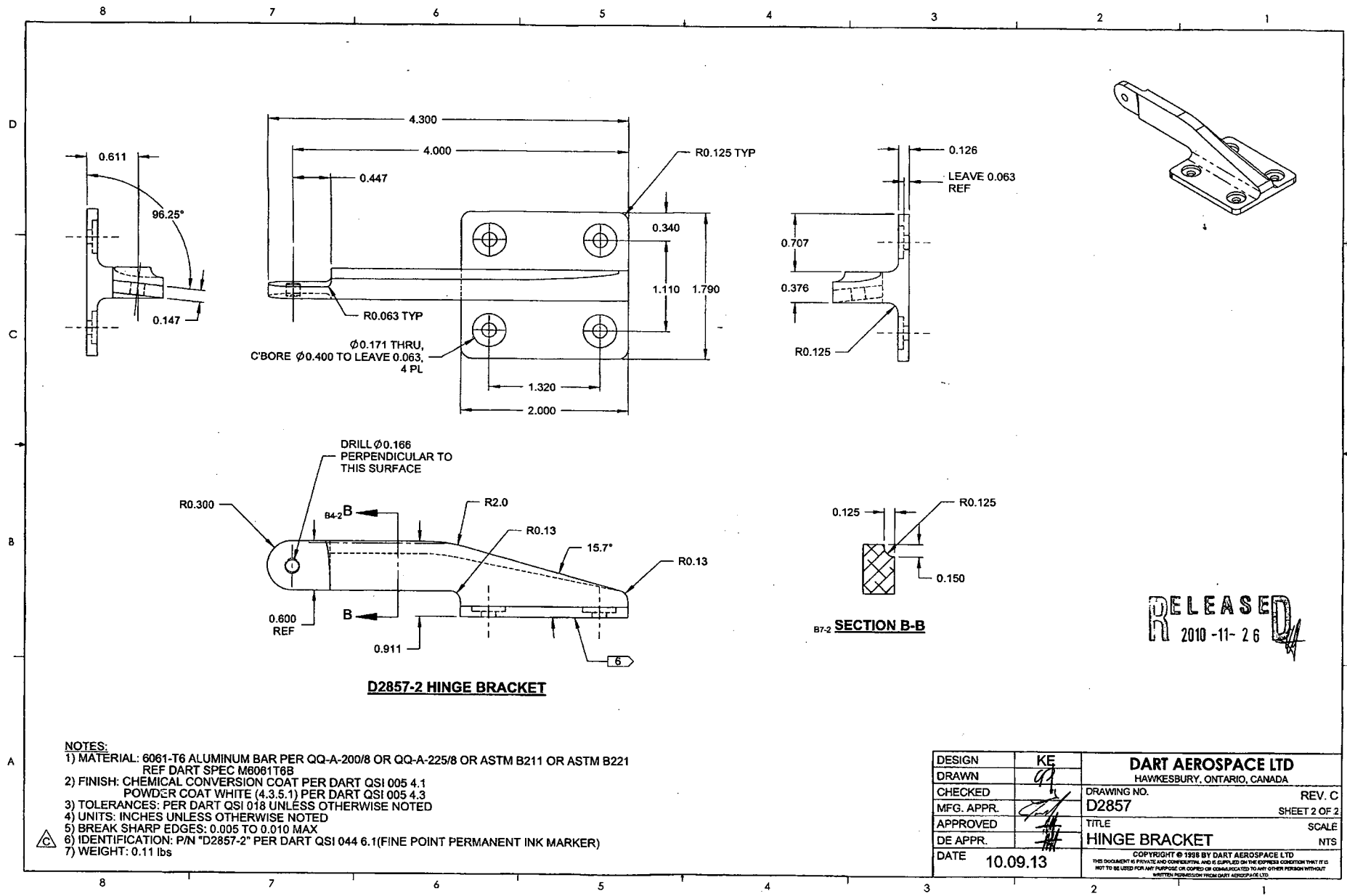
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DESIGN	KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	97		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2857	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		HINGE BRACKET	NTS
DATE	10.09.13	<small>COPYRIGHT © 1998 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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